

Work Order ID 78129

78129

Page 1

December-29-11 10:32:37 AM

Item ID: D3806-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 29/12/2011 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 06/02/2012 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/29 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3806	B								

100 0.00
100
 Cold Saw Memo
 Hyd Mech Cut blanks at 43.600"
 0.00 FK 12/01/21 30 ϕ

110 0.00
110
 HAAS 1 Memo
 HAAS CNC vertical machine #1 1-Mill as per folio FB070 & dwg
 FOLIO REV: 4A
 DWG REV: 6
 2-Deburr as required
 0.00 12-01-22 (Y50)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	<i>OK/CT 12/01/22</i>			<i>50</i>	<i>✓</i>		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>B.A 12/01/24</i>			<i>50</i>	<i>✓</i>		
133 *133* Large Fab Large Fab	Weld per dwg A/R Hardcoat S.S. Batch: _____ Memo 1- On D3806-1, fill cut outs with hardcoat welding rod as per dwg D3805 2059 B Hardcoat Welding Rod BATCH#: _____	0.00 0.00	<i>N</i> <i>W</i>						

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
136 *136* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo <i>N/A</i>	0.00 0.00 <i>h</i>							
137 *137* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <i>W/A</i> Memo	0.00 0.00							

EL 12-1-24 **(450)**

W/O:		WORK ORDER CHANGES					
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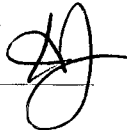
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

12/11/24 

12-01-24
SD

W/O:		WORK ORDER CHANGES					
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Picklist Print

December-29-11 10:32:41 AM

Page 1

Work Order ID: 78129

78129

Parent Item: D3806-1

D3806-1

Parent Item Name: Bar

Start Date: 29/12/2011

Required Date: 06/02/2012

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP Rev:A 08-07-21 new issue DD verified by:ec

IPP Rev:B 08-09-23 redesign DD verified by:EC

IPP Rev:C 08-09-30 redesign DD verified by:EC

D 11.06.03 re-design EC verified by:DD

rev.b as per dwg DD verified by:EC

IPP rev
IPP Rev:E 11.10.04

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased		No		100	f	669.4167	3.66	192.6316			

M304B0 250x0 500

304 BAR .250 x .500

Location

Loc Qty

Loc Code

MAT006

256.122

117842

8.3

119050

21.67

119159

226.152

80.91

MAT050

413.2947

117176

37.8947

119872

375.4

111.727

F.K 12/01/21

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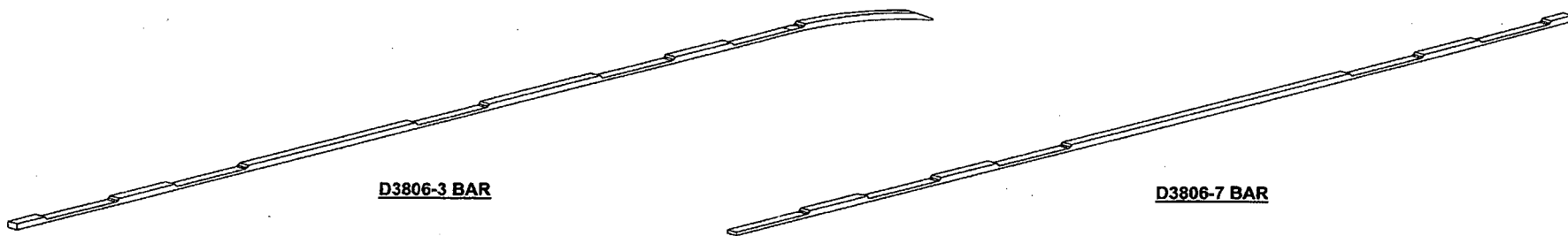
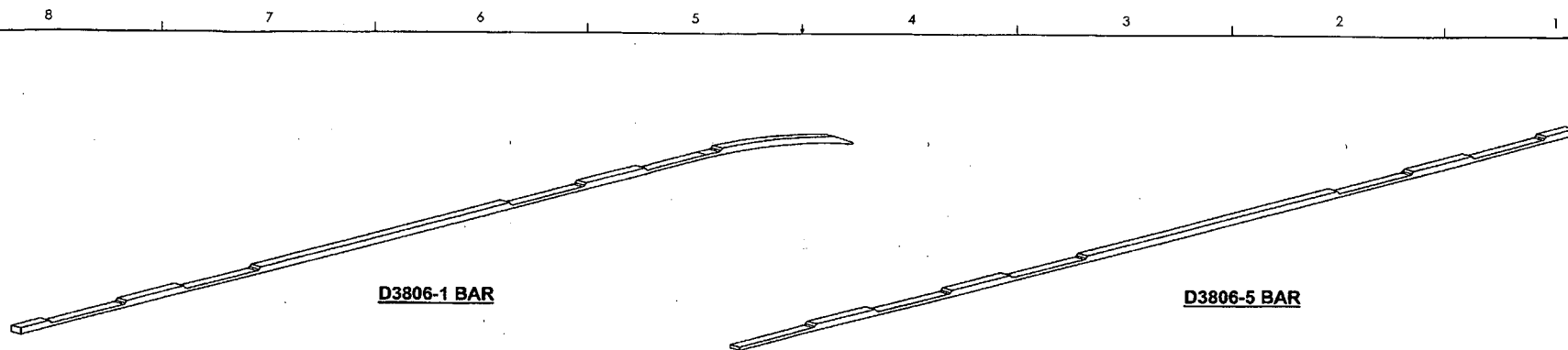
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SHOPEY
REF
UNCONFIDENTIAL
SUBJECT TO

WITHOUT
WORK
NO. 78129 M.L.J

11/12/29

RELEASED
2011-10-03
MD

B	REVISED D3806-11-3 TO EASE MANUFACTURABILITY: 4.0 WAS 4.00; CHANGED MATERIAL STOCK FOR D3806-11-34 5-7 PER PAR11-106	MB	11.09.29
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC. KENT, WA	
DRAWN		DRAWING NO.	REV. B
CHECKED		D3806	SHEET 1 OF 3
MFG. APPR.		TITLE	SCALE
DE APPR.		BAR	NTS
DATE	11.09.29	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

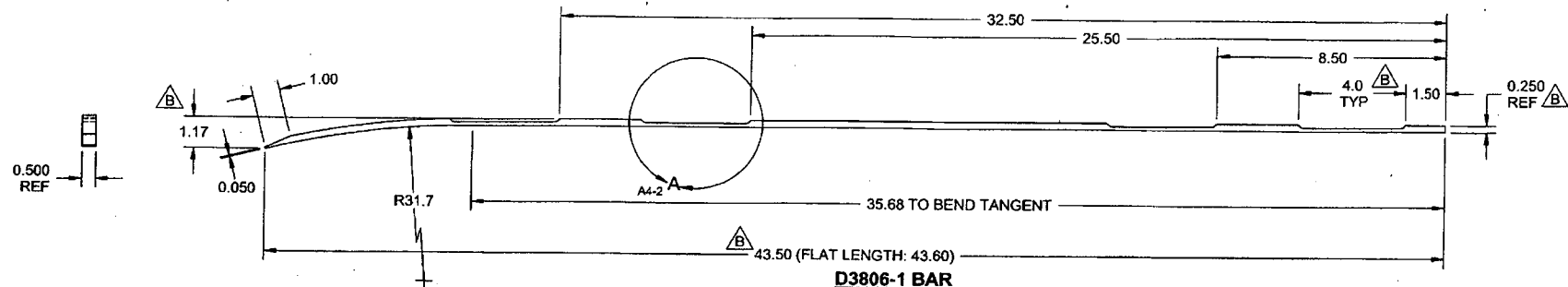
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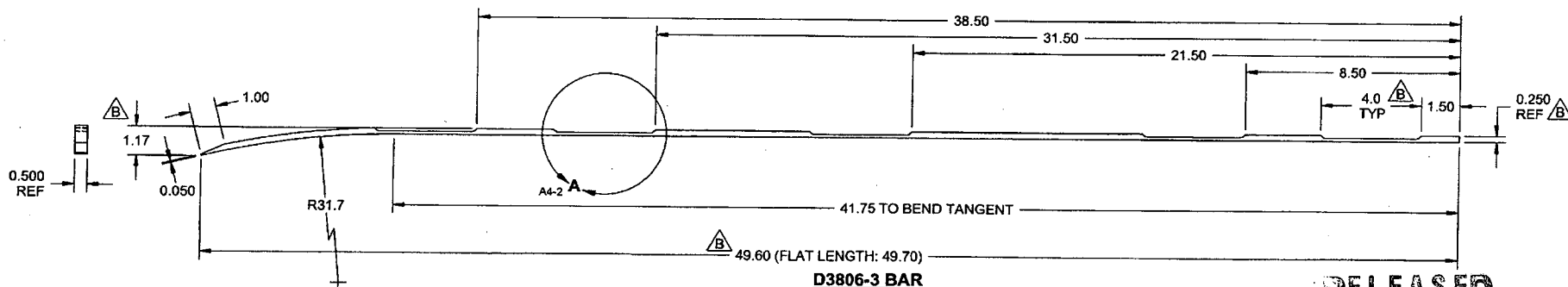
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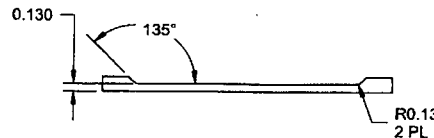
D3806-1 BAR



D3806-3 BAR

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-1 = 1.27 lbs
D3806-3 = 1.42 lbs



DETAIL A
TYP, SCALE 2X

RELEASED
2011-10-03

DESIGN	<i>g</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>g</i>	KENT, WA	
CHECKED	<i>g</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>g</i>	D3806	SHEET 2 OF 3
APPROVED	<i>g</i>	TITLE	SCALE
DE APPR.	<i>g</i>	BAR	NTS
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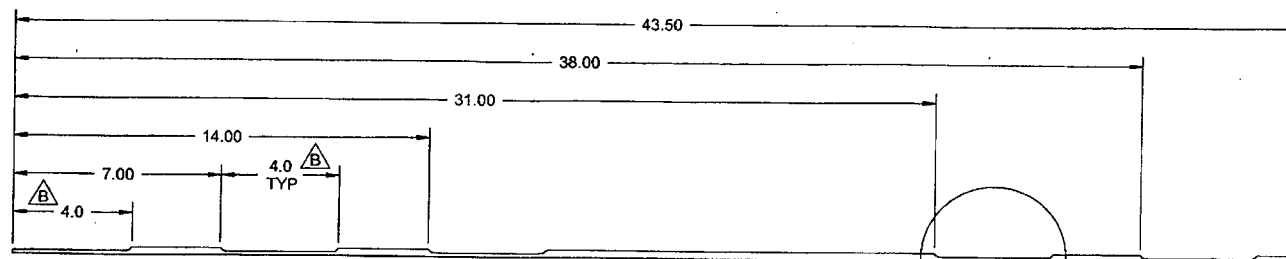
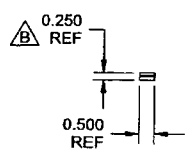
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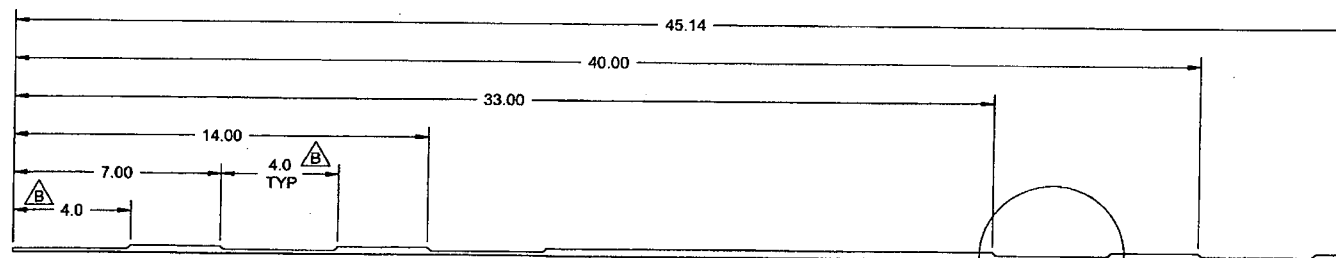
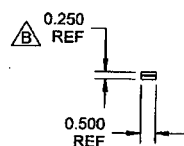
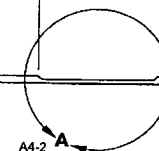
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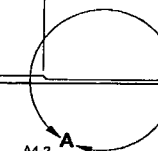
78129



D3806-5 BAR



D3806-7 BAR



RELEASED
2011-10-03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK
REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-5 = 1.22 lbs
D3806-7 = 1.28 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3806	SHEET 3 OF 3
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